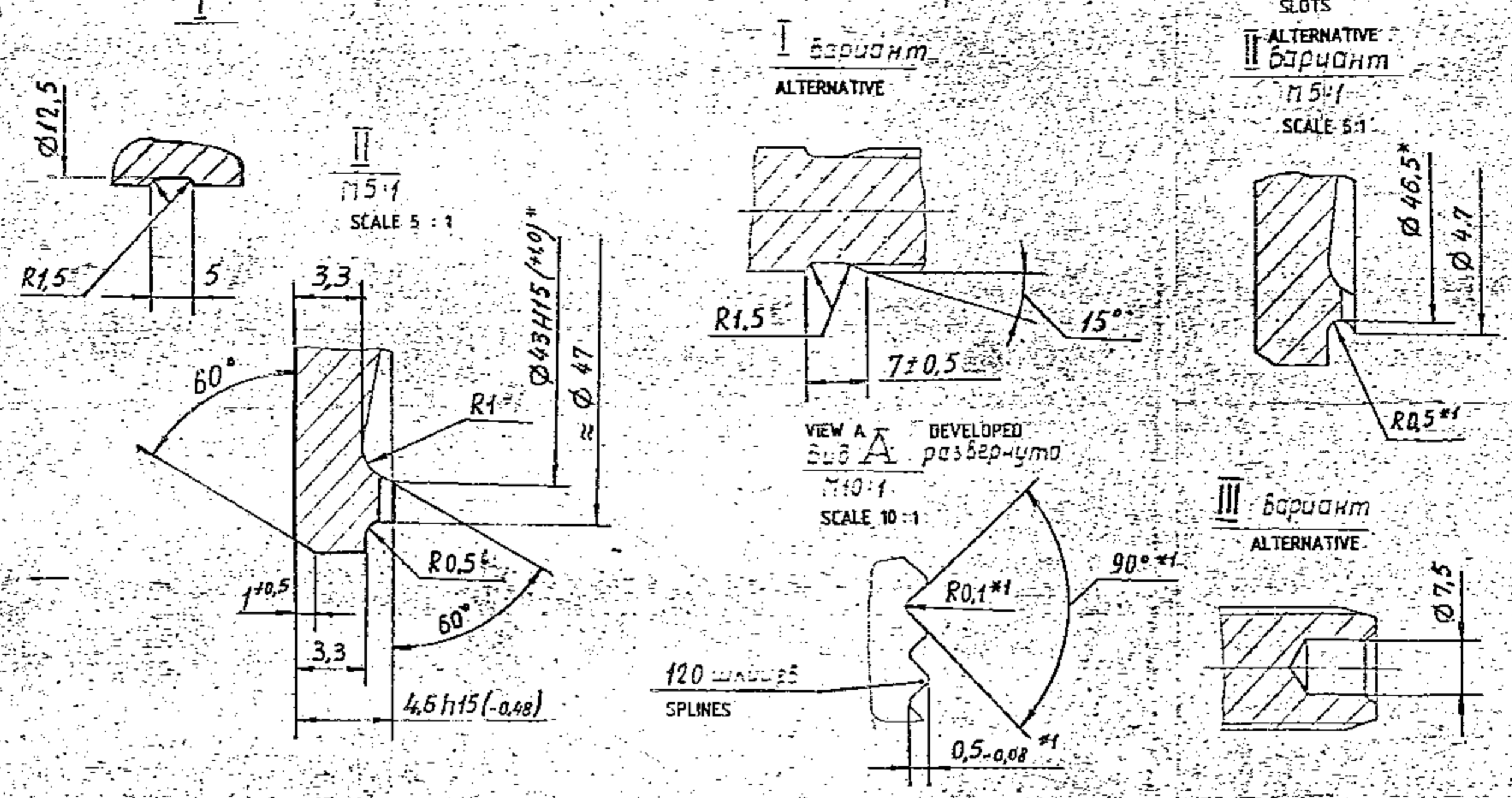


1. Группа контроля III по ТТ-11.
2. HRC, 26...42, кроме места, обозначенного 0205.
3. Неуказанные предельные отклонения, размеров: отверстий по H14; валов по h14; остальных $\pm \frac{IT14}{2}$.
4. Технические требования на резьбу по нормам 82021-00.
5. Торцовые шлицы и расположение их относительно оси поверхности Б проверять специальным калибром в 3^х положениях через 120°. Прилегание должно быть плотным без ощутимой качки. Принимать по контрольному образцу.
6. Допуск торцового биения поверхности В относительно оси среднего диаметра резьбы не более 0,04 мм на диаметре Д.
7. Допуск радиального биения поверхности Б относительно оси среднего диаметра 0,03 мм, не более.
8. Допускается подкамливание остальных поверхностей.
9. Допускается при накатке резьбы закругление гребешков $R=0,17$ мм, не более.
10. Допускается цементация поверхности Г $h=1,2$ мм, не более.
11. Допускается отсутствие центрального отверстия.
12. На дне канавки выхода резьбы риски не допускаются.
13. Деталь проверить на магнитном дефектоскопе. Технические требования и правила приемки согласно ТТ 143-17.
14. Диаметр клейма 5 мм, не более.
- 15.* Размеры контролировать до накатки торцовых шлицев.
- 15.* Размеры обеспечить инструментом.
17. Покрытие хим. окс. прм.

- 1) INSPECTION GROUP III AS PER TT-11.
- 2) HRC 26...42 UNLESS OTHERWISE SPECIFIED.
- 3) UNSPECIFIED LIMIT DEVIATION OF DIMENSIONS OF HOLES AS PER H14, SHAFT PER h14 AND OTHER DIMENSIONS $\pm \frac{IT14}{2}$.
- 4) TECHNICAL REQUIREMENTS FOR THE THREAD ARE AS PER STANDARD 82021-00.
- 5) THE FACE SPLINES AND THEIR POSITION RELATIVE TO THE AXIS OF SURFACE B BE CHECKED WITH A SPECIAL GAUGE. THE CHECK SHOULD BE CARRIED OUT AT 3 POINTS EVERY 120°. THE ENGAGEMENT SHOULD BE FULL WITHOUT PLAY AND ACCEPTED ON TEST SPECIMEN.
- 6) THE RUNOUT OF SURFACE B RELATIVE TO THE AXIS OF THE DIAMETER OF THE THREAD SHOULD NOT EXCEED 0.04mm ON DIAMETER A.
- 7) THE RADIAL RUNOUT OF SURFACE B RELATIVE TO THE PITCH DIAMETER OF THE THREAD SHOULD NOT EXCEED 0.03mm.
- 8) THE REPEATED CARBURIZATION OF THE REMAINING SURFACE IS ALLOWED.
- 9) WHEN ROLLING THE THREAD THE CRESTS MAY BE BLUNTED TO A RADIUS NOT EXCEEDING 0.17mm.
- 10) SURFACE G MAY BE CARBURIZED THE DEPTH OF CARBURIZATION SHOULD NOT EXCEED 1.2mm.
- 11) CENTRE HOLE MAY BE DRILLED.
- 12) MARKS ARE NOT ALLOWED ON THE BOTTOM OF GROOVE TO WHICH THE THREAD COMES.
- 13) THE COMPONENT SHOULD BE CHECKED FOR DEFECTS ON MAGNETIC FIELD FLAW DETECTOR. TECHNICAL REQUIREMENTS AND ACCEPTANCE RULES ARE IN ACCORDANCE WITH TECHNICAL REQUIREMENTS 143-17.
- 14) MARKING DIAMETER SHOULD NOT EXCEED 5mm.
- 15) DIMENSIONS SHOULD BE CHECKED BEFORE FORMING THE FACE SPLINES. MARKING DIAMETER SHOULD NOT EXCEED 5mm.
- 16) DIMENSIONS TO BE ENSURED BY TOOL.
- 17) COATING: CHEMICAL OXIDIZING OIL FINISHING.



(A) ALT. MATERIAL: BS: 970. STEEL GRADE: En36B.

CHEMICAL COMPOSITION	MECHANICAL PROPERTIES
C = 0.12 TO 0.18	ULTIMATE TENSILE STRENGTH — 102 kg/mm ² (min)
Si = 0.10 TO 0.35	ELONGATION % — 13 (min)
Mn = 0.30 TO 0.60	IZOD IMPACT — 4.8 kgm/cm ² (min)
Cr = 0.60 TO 1.10	
Ni = 3.0 TO 3.75	
P = 0.05 (Max)	
S = 0.05 (Max)	

(B) EQUIVALENT MATERIAL
EN 36B TO BS: 970/
13 Ni13 Cr 3 TO 15: 4432-1988

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

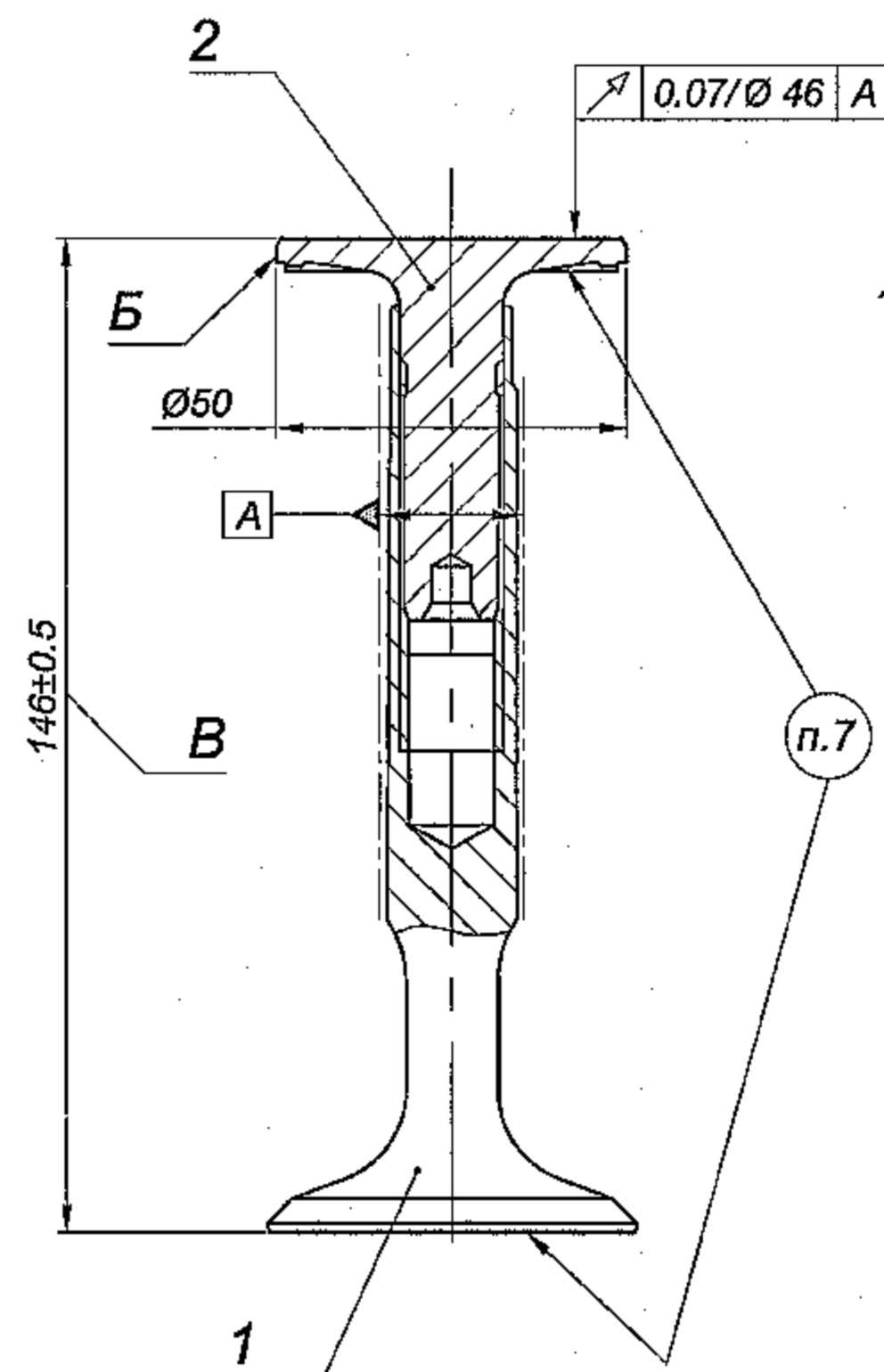
EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.15 Kg.	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	CHK	APPD	DATE	SCALE	TOLERANCE ON DIMS	TITLE
			23-3-88	2:1	UNLESS OTHERWISE STATED IS 2102-69	VALVE DISC
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - STEEL 12XH3A USED ON 306-06-35 C6 TY 14-1-301-72 C6 306-07-3A CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLE) AVADI			
			S. CAT. NUMBER 306-47-2			



DRAWING NUMBER
Cb.306-06-12

SHEET No. 1 OF 1



1. Before Assembly:
 - a). Valve (item 1) and valve disc (item 2) should be thoroughly washed and blow off with dry compressed air.
 - b). Disc thread should be lubricated with mixture of castor oil GOST 6757-73 and graphite ГЛС-2 as per GOST 5420-74 in the ratio of 5:1. It is permitted to use graphite as per GOST 5279-74.
2. The disc (item 2) should be screwed in to the valve stem (item 1) upto the dimension 'B'.
3. While screwing in the torque should be (2.5...12.5)Nm [(25...125)kgf.cm]
4. Shake in disc (item 2) with respect to valve stem (item 1) at the entire dimension 'B' is not allowed. Shake in disc while going in to guiding portion (Ø14.2 mm) of valve stem should not be more than 0.04 mm. Checking of disc shakness to be carried out on surface 'B' and datum surface 'A'.
5. Tolerance of end play is ensured in any position of disc with respect to valve stem while unscrewing it from the dimension 'B' by one turn.
6. Slight traces of rubbing and external oxidized surface are allowed on guiding portion of disc (item 2)
7. Pairing number to be marked by etching from 1 to 99. For every one hundred numbers marked with alphabetical letter.

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

PILOT SAMPLE SHOULD BE APPROVED BY A I I S P BEFORE BULK PRODUCTION.

EST. WT. (Kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.365	

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	APD	MATERIAL :-	USED ON :-
CHD	DATE		C6 406-16-15 C6 406-17-15
APD	SCALE:- 1:1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DATE	DIMENSIONS IN mm	TITLE :-	
	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69	INLET VALVE ASSY	
ISSUE	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE			Cb.306-06-12
NATURE OF AMENDMENTS			

F-3
65
166
SIZE A2

USED ON

ITEM No.

DRAWING NUMBER

D S CAT NUMBER

DESCRIPTION

QTY

REMARKS

Cb.306-06-12

INLET VALVE ASSY

ITEM LIST

1

Cb.306-45-01 & I/L

INLET VALVE ASSY

1

2

306-47-2

VALVE DISC

1

Cb 406-16-15
Cb 406-17-15

ML CREATED BASED ON RUSSIAN ORIGINAL ISSUE - 2

ISSUE

DATE

NATURE OF AMENDMENTS

ISSUE

DATE

NATURE OF AMENDMENTS

F - 3

64/166

DRN

[Signature]

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.

CHD

[Signature]

TITLE :

INLET VALVE ASSY

APPD

[Signature]

DATE

14. 5. 07

SHT. NO. 1 OF 1

D S CAT NUMBER

ITEM LIST FOR
Cb.306-06-12